



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2893-1

Job Sheet 191407



Part No: D2893-1

Job Qty: 12 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/28/19

Job Tracking No:

Due Date: 4/4/19

Created By: Marie Lajeunesse

Type: Stock *STOCK*

Description:

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	4/4/19		0.33	23.53	HAAS - 1		<i>K-1 19/03/28</i>
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	12 pcs	4/4/19		0.00	0.00	QC 8 - 12		<i>mml 19/03/28</i>
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
130	Crosstubes - 2 - B4B	12 pcs	4/4/19		0.00	2.00	QC 8 - 8		<i>AA 19-3-28</i>
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							Crosstubes - 1 - B4B		
130	Crosstubes - 2 - B4B	12 pcs	4/4/19		0.00	2.00	Crosstubes - 2 - B4B		<i>AA 19-3-28</i>
							Crosstubes - 3 - B4B		
							Crosstubes - 4 - B4B		



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Container No: S167333



Part: D2893-1

Job No: 191407

Serial No/Batch: S167333

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/28/19

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140 QC 3	12 pcs	4/4/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
170 Packaging 3-1 - Stock - B4B	12 pcs	4/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	L6050 A8 19-3-29
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	12 pcs	4/4/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS
40
9-89

MAR 29 2019

L6050

A8 19-3-29

DAS
21
9-89

MAR 29 2019

Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081

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Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. *138852 exp 4/19*
140 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	6 pcs (.5 ea)	100-HAAS 4 Axis	<i>5145048</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	6	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 191407
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.991	2.994	2.993	2.993	2.991
AB	0.440	0.460		.455	.455	.450	.448	.449
AC	0.125	0.160		.140	.140	.140	.140	.139
AD	0.040	0.060		.053	.053	.052	.051	.049
AE	0.188	0.193		.188 Ø	.188 Ø	.188 Ø	.188 Ø	.188 Ø
AF	0.125	0.160		.142	.142	.139	.139	.139
AG	0.140	0.160		.151	.151	.149	.149	.149
AH	1.360	1.400		1.375	1.375	1.373	1.374	1.374
AI	0.040	0.060		.051	.051	.050	.050	.050
AJ	1.190	1.230		1.218	1.219	1.210	1.211	1.212
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AM	0.240	0.260		.250 R	.250 R	.250 R	.250 R	.250 R
AN	2.518	2.538		2.538	2.538	2.538	2.538	2.538
AO	84.39	90.39		87.00°	87.00°	87.00°	87.00°	87.00°
AP	0.261	0.266		.261 Ø	.261 Ø	.261 Ø	.261 Ø	.261 Ø
AQ	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AR								
AS								
AT								
Accept/Reject								

Measured by: L.L.S.	Date: 20/9/07/26
Audited by: [Signature]	Date: 19/03/28
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	[Signature]

DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	2.985	3.005		2.990	2.986	2.988	2.990	2.990
AB	0.440	0.460		0.450	0.450	0.450	0.450	0.450
AC	0.125	0.160		0.139	0.160	0.160	0.160	0.160
AD	0.040	0.060		0.049	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AF	0.125	0.160		0.136	0.136	0.136	0.136	0.136
AG	0.140	0.160		0.150	0.147	0.148	0.148	0.148
AH	1.360	1.400		1.374	1.371	1.371	1.371	1.371
AI	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AJ	1.190	1.230		1.210	1.215	1.215	1.215	1.215
AK	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AL	0.053	0.073		0.063 R	0.0625	0.0625	0.0625	0.0625
AM	0.240	0.260		0.250 R	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063 R	0.0625	0.0625	0.0625	0.0625
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>MM RF</i>	Date:	<i>2019/03/27</i>
Audited by:	<i>MM</i>	Date:	<i>19/03/28</i>
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	3	4	5
HAAS Section								
AA	2.985	3.005		2.990	2.990			
AB	0.440	0.460		0.450	0.450			
AC	0.125	0.160		0.160	0.160			
AD	0.040	0.060		0.050	0.050			
AE	0.188	0.193		0.188	0.188			
AF	0.125	0.160		0.136	0.136			
AG	0.140	0.160		0.148	0.148			
AH	1.360	1.400		1.371	1.371			
AI	0.040	0.060		0.050	0.050			
AJ	1.190	1.230		1.215	1.215			
AK	0.010	0.020		0.010	0.010			
AL	0.053	0.073		0.0625	0.0625			
AM	0.240	0.260		0.250	0.250			
AN	2.518	2.538		2.528	2.528			
AO	84.39	90.39		87.39	0.261			
AP	0.261	0.266		0.0025	0.0025			
AQ	0.053	0.073						
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>[Signature]</i> DAS 1 9-89	Date: 19/03/28
Audited by: <i>[Signature]</i>	Date: 19/03/28
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
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